

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 146177

May 10, 2016 9:05:03 AM

146177

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Item ID: D2616-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 5/24/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/7/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						10			16-517
QC	Memo	0.20							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									10 x 4 16/06/03
HandFinish	Memo	0.40							
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	M 130746 -					10	0	16-06-6.	DAS 34 9-89
Powdercoat	Memo	0.10							
Powder Coating	Note:Mask large hole TEMPERATURE: 320° FINISH TIME: 11:20. OVEN 11:50.								

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May 10, 2016 9:05:03 AM

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 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 5/24/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/7/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						10	FF	JUN 06 2016	
QC	Memo	0.10							
Quality Control									
170		0.00							
170	Small Fab					10	FF	JUN 06 2016	
Small Fab	Memo	0.70							
Small Fab	1-Coat bearing in light oil2-Press Bearing in D2616-23-Stack as per Dwg D2616 using DT8019 4- Touch up paint if required								
180	QC5- Inspect part completeness to step on W/O	0.00							
180						(16)	16-06-06		
QC	Memo	0.20							
Quality Control									

DAS
9
8-89

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QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER : _____																																																																		

Work Order ID 146177

May 10, 2016 9:05:03 AM

146177

Page 4

Item ID: D2616-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 5/24/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/7/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 519	0.00							
190									
Packaging	Memo	0.10							
Packaging									
									16-6-6
200	QC21 - Final Inspection - Work Order Release	0.00							
200									
QC	Memo	1.00							
Quality Control									

ML3 JUN 08 2016
~~ML3 JUN 07 2016~~

SA 16.6.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐					

Picklist Print

May 10, 2016 9:05:08 AM

Page 1

Work Order ID: 146177

146177

Parent Item: D2616-2

D2616-2

Parent Item Name: Mounting Lug

Start Date: 5/24/2016

Required Date: 6/7/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:C00.06.22Removed P/O for powder coatEC
IPP Rev:D 08-01-07 rev E as per dwg ECN1069 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued DAS	Date Issued	Status
D2611		Manufactured	No				Each	30.0000		10	30 9-89	JUN 06 2016	

D2611
Bearing

**

Location

Loc Qty

Loc Code

ST008A

30

B 131 1304

134006

10

134776

20

M6061T6B1.000X02.00
0

Purchased No

f

47.4520

1.66

DAS

44

9-89

16-05-12

**

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

Location

Loc Qty

Loc Code

MAT

47.452

M132582

2.052

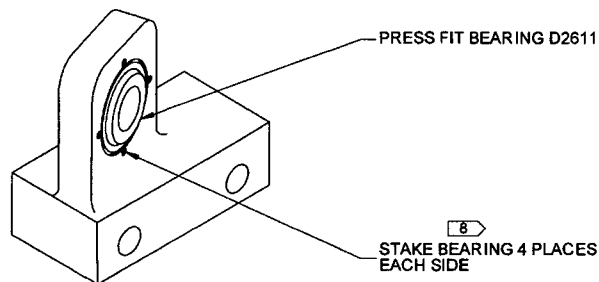
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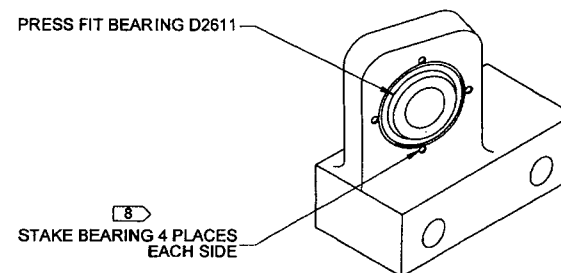
M134677

24

1.72



D2616-1 FWD MOUNT LUG



D2616-2 FWD MOUNT LUG

QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

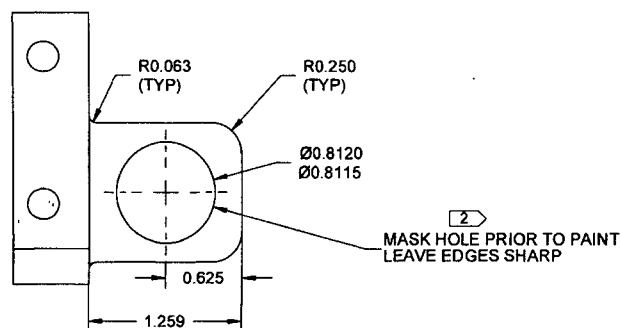
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.

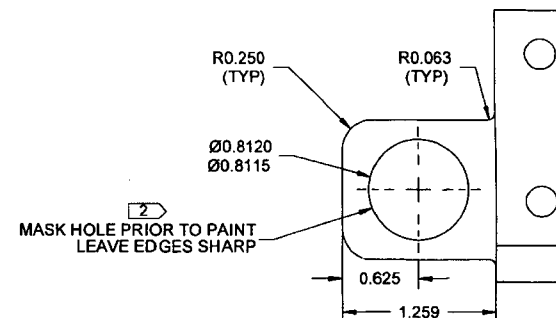
20160510
54
14/6/77

RELEASED
07.12.22

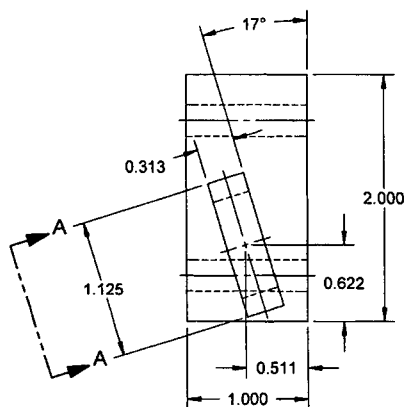
E	UPDATE DWG: SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6-B2	KE	97.07.31
C	REMOVE D2616-3	BW	97.08.04
B	RE-DESIGN	KE	97.05.06
A	ORIGINAL ISSUE	BW	96.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2616	SHEET 1 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.	W	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



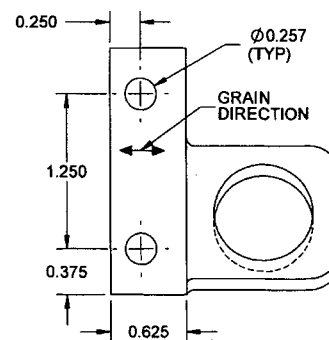
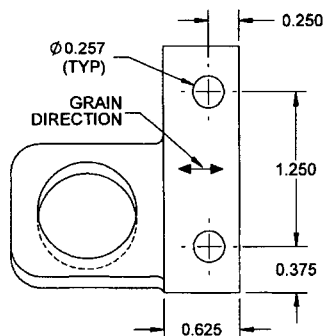
VIEW A-A



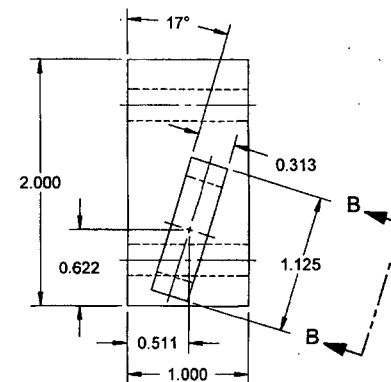
VIEW B-B



D2616-1A LUG



D2616-2A LUG



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK BEARING HOLE PRIOR TO PAINT
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
07.12.12

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	LE	DRAWING NO. D2616	REV. E
MFG. APPR.	MD	TITLE FWD MOUNT LUG	SHEET 2 OF 2
APPROVED	MD	SCALE 1:1	
DE APPR.	MD		
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	146177
Description: Mounting Lug		Part Number:	D2616-2
Inspection Dwg: D2616	Rev: D3 <i>EA</i> 16.06.08	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0,250	✓		MIP-04	vern
1.250	+/-0.010	1,250	✓			
0.375	+/-0.010	0,372	✓			
0.625	+/-0.010	0,620	✓			
Ø0.257	+0.006/-0.001	0,259	✓			
1.000	+/-0.010	1,002	✓			
2.000	+/-0.010	2,000	✓			
1.125	+/-0.010	1,125	✓			
0.313	+/-0.010	0,313	✓			
17°	+/-0.5°	17°	✓			
1.259	+/-0.010	1,259	✓			
Ø0.625	+0.008/-0.001	0,624	✓			
R0.250	+/-0.010	0,250	✓		—	Radius gauge
R0.063	+/-0.010	0,063	✓		—	...
Ø0.8115- Ø0.8120	N/A	0,812	✓		—	Gauge pin

Measured by: <i>EA</i>	Audited by: <i>SL</i>	Prototype Approval:	N/A
Date: 16/06/14	Date: 16-5-17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM <i>EA</i>	<i>SL</i>